

Date: Wednesday, 27/08/2008 12:43:10 PM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 41638		
Estimate Number	: 10175		
P.O. Number	:	Part Number	: D2570
This Issue	: 27/08/2008 S.O. No. :	Drawing Number	: D2570 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: B
Previous Run	: 40986	Material	:
Written By	: <u>27/08.08.26</u>	Due Date	: 03/09/2008 Qty: 200 Um: Each
Checked & Approved By	:		
Comment	: Est E 02.08.29 Re-format; Removed finishing; Material changeK J est F 07.07.06 rev B dwg EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M303R0750	303 Round Bar 0.750
-----	-----------	---------------------



Comment: Qty.: 0.0810 f(s)/Unit Total : 16.1910 f(s)
Material: Ø0.750 AISI 303 SS Rod (M303R0.750)
Batch M108877

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL
Machine as per folio FA198
Deburr

SA 08/08/28

(206)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 08/08/28

(206)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

cmf 08/08/30

(206)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

08/08/2 (206)

Date: Wednesday, 27/08/2008 12:43:10 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 41638

Part Number: D2570

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/03 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



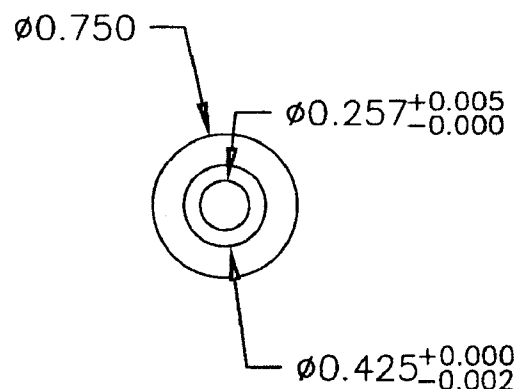
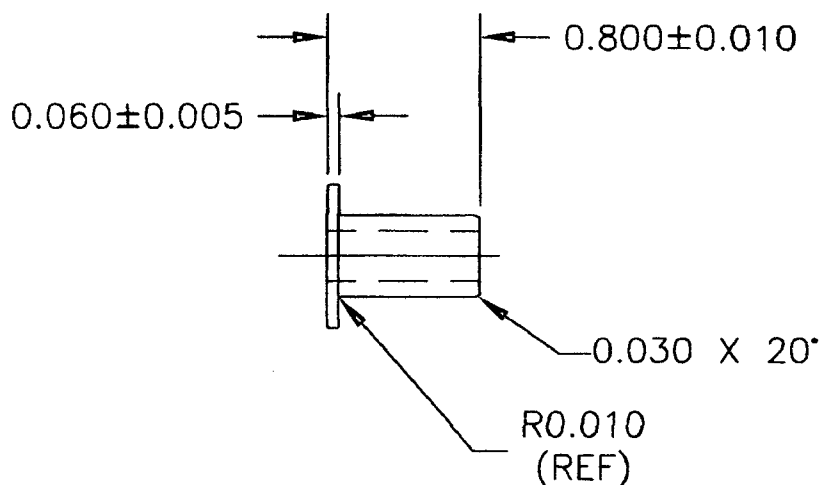
MF 08-07-03



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2570	REV. B SHEET 1 OF 1
DATE 07.04.17		TITLE BUSHING	SCALE 1:1
A	96.09.16	NEW ISSUE	
B	07.04.17	UPDATE NOTES	

RELEASED
07.06.28

W/O D2570
41638



D2570 BUSHING

D2570 BUSHING

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX

Copyright © 1996 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD		Work Order: 41639
Description: Bushing		Part Number: D2570
Inspection Dwg: D2570 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.800	+/-0.010	.806	/			
0.060	+/-0.005	.063	/			
R0.010	+0.010/-0.000	R.010	/			
Ø0.425	+0.000/-0.002	Ø.424	/			
Ø0.257	+0.006/-0.001	Ø.261	/			
Ø0.750	+/-0.010	Ø.745	/			
0.030 x 20°	+/-0.010	.030 x 20°	/			

Measured by: SD	Audited by: [Signature]	Prototype Approval: N/A
Date: 08/08/28	Date: 08/08/30	Date:

Rev	Date	Change	Revised by	Approved
A	03.12.08	New Issue	KJ/RF	
B	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	
C	07.07.17	Dimensions updated per Dwg Rev. B	KJ/JLM	
D	08.07.23	Tolerance for Ø0.257 revised	KJ/DD	